

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001619**Date Inspected:** 25-Oct-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Jin Long**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Strut Sub-Assembly**Summary of Items Observed:**

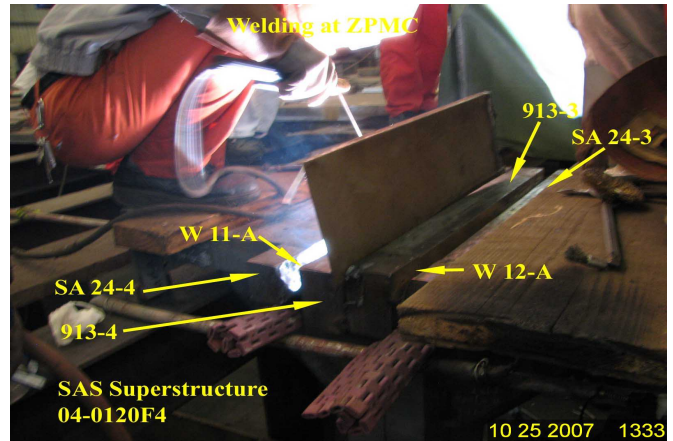
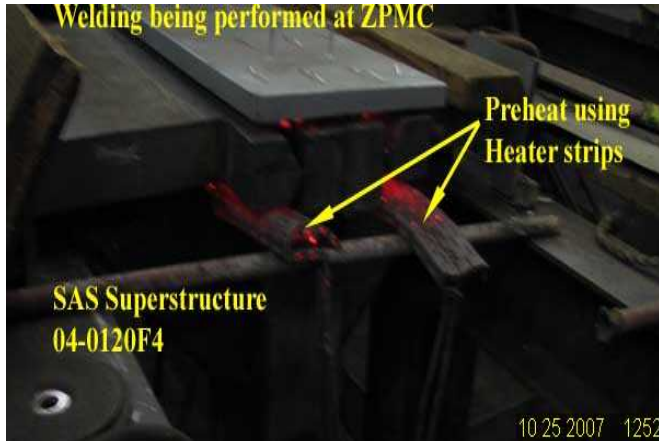
Caltrans Quality Assurance (QA) Inspector, Timothy McClendon was present to observe Welding of the Caltrans Mock-up # 89.00, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item-1 89 Corner Splice Weld #11-A, Plate #913-4 to plate #SA24-4. Welding of the filler passes was being performed by Zhenhua Port Machinery Company (ZPMC) certified welder Wang Zhonghua #054467. Using the Shielded Metal Arc Welding (SMAW) process. The welding procedures utilized were WPS-B-T-3211-TC-U5b using welding rods 9018M-H4R. A rod box was used to maintain the specified temperature for the welding rods. The CWI present was Xu Jin Long. The welding parameters recorded by this QA Inspector were, Amps 199, Volts 24.3, Travel Speed 120 mm/min. and the Temperature was 160C.

Item-2 89 Corner Splice Weld# 12-A, Plate #913-3 to plate #SA24-3. Welding of the filler passes was being performed by Zhenhua Port Machinery Company (ZPMC) certified welder Dai Lu #048659. Using the Shielded Metal Arc Welding (SMAW) process. The welding procedures utilized were WPS-B-T-3211-TC-U5b using welding rods 9018M-H4R. A rod box was used to maintain the specified temperature for the welding rods. The CWI present was Xu Jin Long. The welding parameters recorded by this QA Inspector were, Amps 189, Volts 24.5, Travel Speed 130 mm/min. and the Temperature was 160C.

WELDING INSPECTION REPORT

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Summary of Conversations:

No relevant conversations spoken on this day.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: McClendon, Timothy

Quality Assurance Inspector

Reviewed By: Cuellar, Robert

QA Reviewer